

Date: Tuesday, 7/11/2006 1:05:47 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 27867B		
Estimate Number	: 10462		
P.O. Number	: N/A	Part Number	: D32782
This Issue	: 7/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3278 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27593B	Drawing Revision	: B
		Material	: N/A
Written By	: <i>SEA COMMENT BELOW</i>	Due Date	: 7/30/2006
Checked & Approved By	: <i>J.F. 06-07-11</i>	Qty:	40 Um: Each
Comment	: Est:A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.4572 f(s)/Unit Total: 18.2868 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
 (M6061T6B1.000x02.000)

Batch:

M19059/1827PCS
M18745/18PCS

J.F. 06/07/11

45

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

J.F. 06/07/11

45

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

J.F. 06/07/16

40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/07/16

40

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MS 06/07/16

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/16	3	The piece was not set well in the fix fixture. Fixture have to be change. Part lifts when vice is tightened.	CP 06.08.09 pr QSI 042	Fixture - Clamp to be re-made. 5 parts too thin at top hole location. - Scope replace.	J.F. 06/07/16	06-07-17	CP 06.08.09 pr QSI 042	06-07-17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/08/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/11/2006 1:05:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 27867B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-07-20 40

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/26 (40)
DL

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 419

PB 06/08/04 (40)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/09

Job Completion



W 06-08-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27867B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.099"				
0.359	+/-0.005	0.359"				
0.609	+/-0.010	0.617"				
0.250	+/-0.010	0.250"				
1.480	+/-0.005	1.485"				
R0.125	+/-0.010	R0.125"				
0.119	+0.005/-0.004	0.119"				
2.439	+/-0.010	2.440"				
1.980	+/-0.010	1.982"				
R0.130	+/-0.010	R0.130"				
Ø0.257	+0.005/-0.000	Ø.258"				
R0.375	+/-0.010	R0.379"				
0.875	+/-0.010	.876"				
0.500	+/-0.010	.500"				
R0.400	+/-0.010	R0.400"				
1.720	+/-0.010	1.721"				
R0.125	+/-0.010	R0.125"				
0.125	+/-0.010	.126"				

Measured by: J.F.	Audited by: MB	Prototype Approval:	N/A
Date: 06/07/15	Date: 06/07/15	Date:	N/A

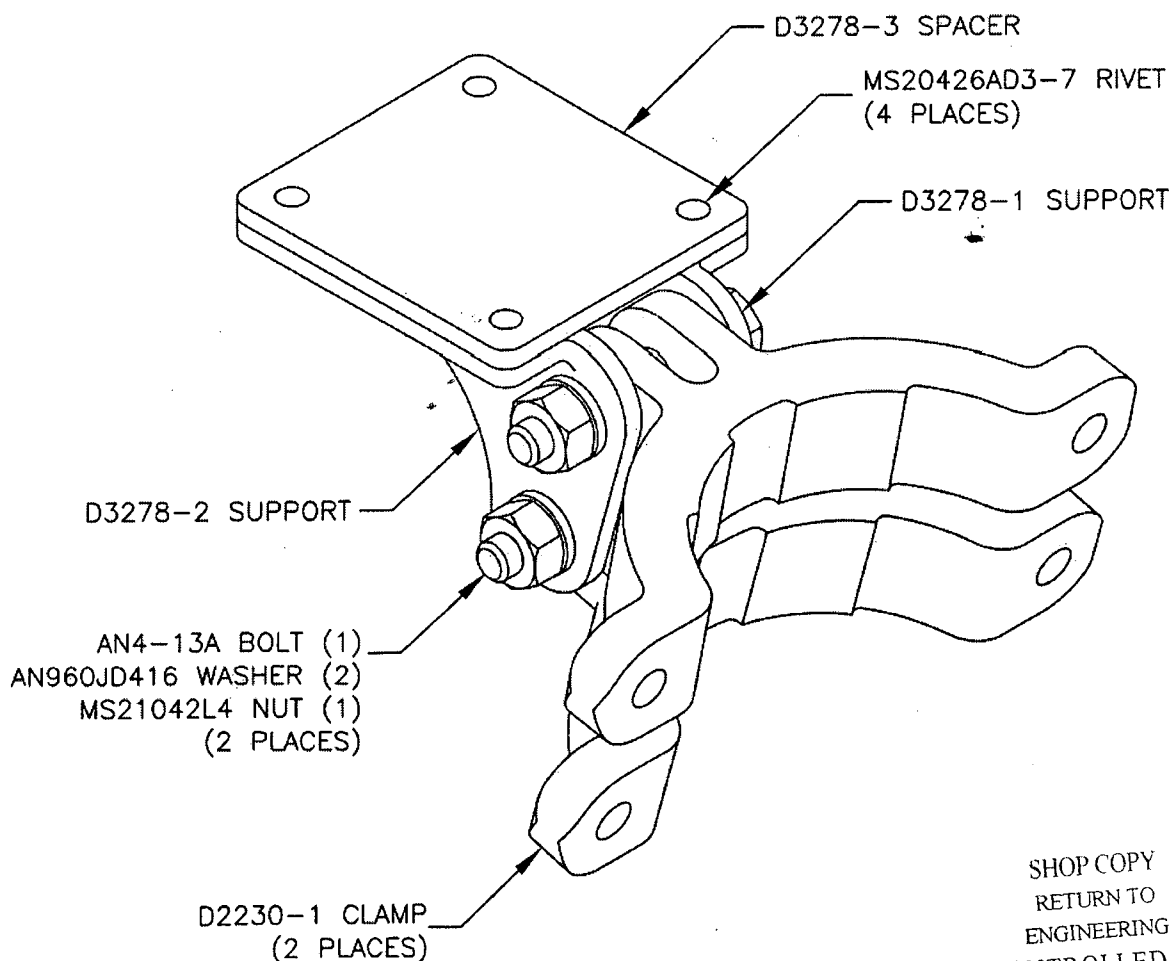
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	



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				D3278	SHEET 1 OF 3
DATE	05.03.31			TITLE	SCALE
				SUPPORT ASSEMBLY	NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



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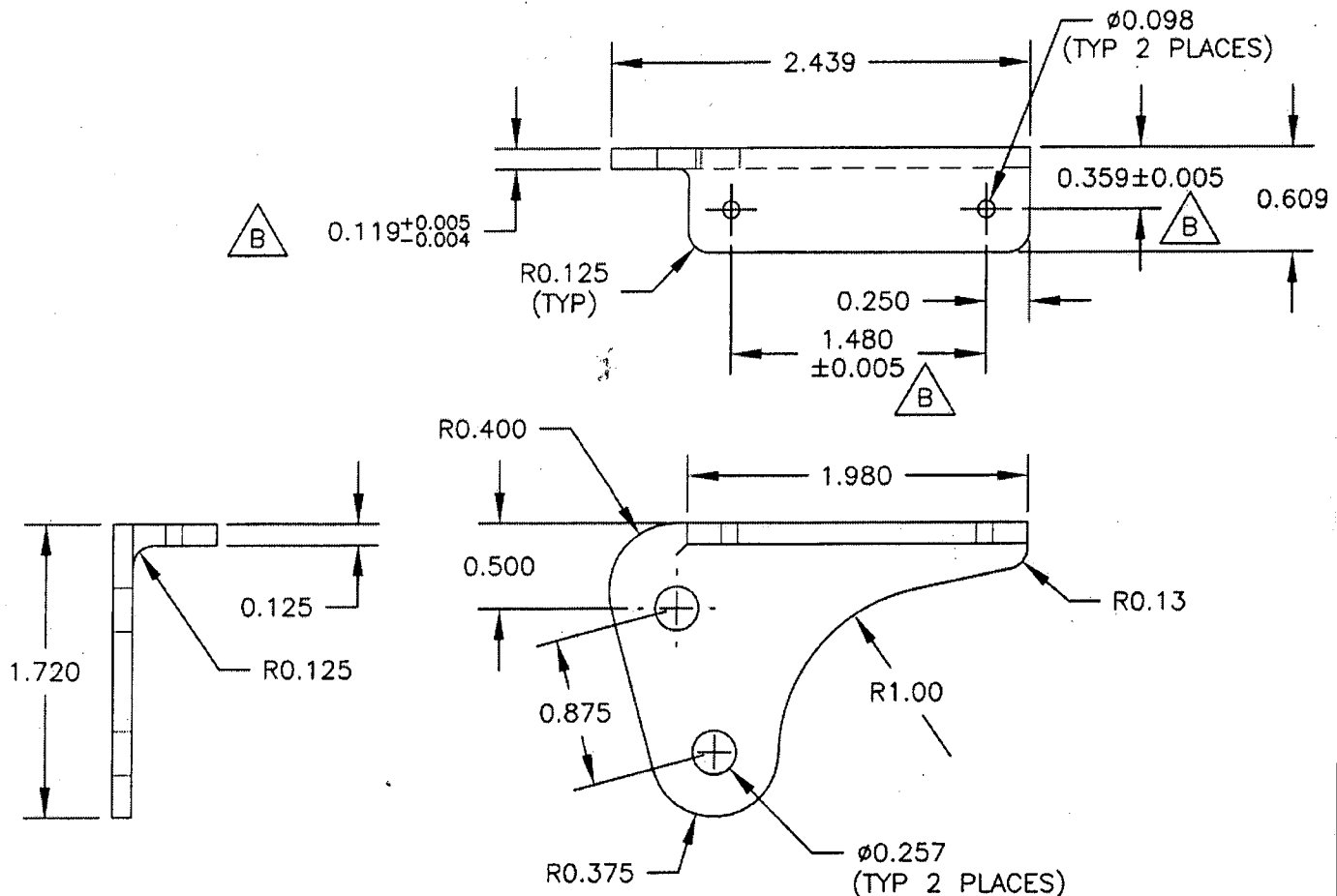
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

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05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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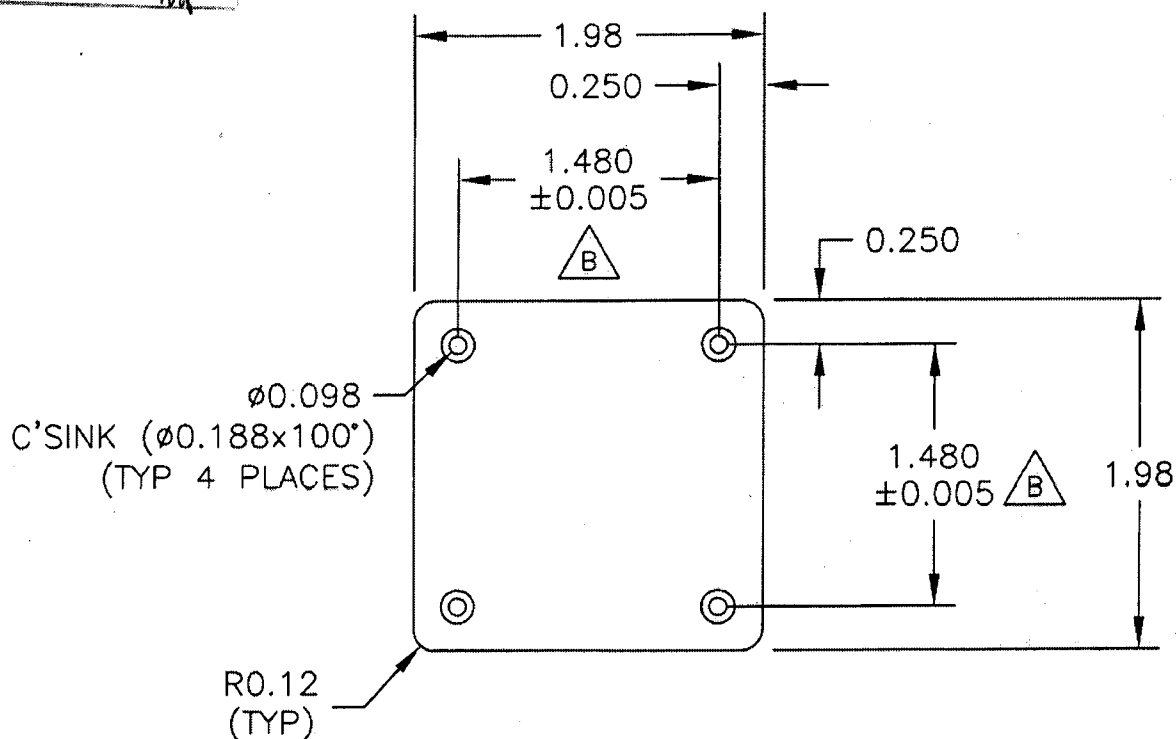
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				REV. B
DATE	05.03.31	TITLE	SUPPORT ASSEMBLY	SHEET 3 OF 3
				SCALE 1:1

RELEASED05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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